

Work Order ID 55126

January 06, 2010 3:24:38 PM

Page 1

Item ID: D3954-3

Accept

Revision ID:

Item Name: GWT Knob

Start Date: 1/6/2010 Start Qty: 10.00

Required Date: 1/13/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-01-06 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3954

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3854

Dwg Rev:

Prog Rev:

2-Deburr if necessary

=> M-L 10/01/12

7X

LB 10-1-11

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

FB 10-1-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ S10/01/12

(X7)

130

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

1-OPEN TO TAP DRILL SIZE

2-TAP AS PER DWG D3954

M.A 10/01/12

7

Ø

140

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

⇒ S10/01/13

(X7)

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



SprayPaint

Spray Painting

M113544

0.00

Start: 2:18pm

Temp: 370°F

Stop: 2:45pm

del

10-01-13

X7

Memo

1- MASK THREADS PRIOR TO PAINTING AS PER DWG

2- SPRAY PAINT YELLOW AS PER DWG

A/R BATCH

Powder coat Hybrid yellow HS112 Y12 (Ref. PAR10-001 7/10-01-07)

160



QC

Quality Control

QC14- Inspect Spray Paint
FOR 3

0.00

Memo

0.00

OK 10-01-14

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

PC 10/11/14 (7)

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Item ID: D3954-3

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Setup Start

Revision ID:

Stop

Item Name: GWT Knob

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Required Date: 1/13/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15 J
MF 10-1-14

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Picklist Print

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Page 1

Work Order ID: 55126



Parent Item: D3954-3



Parent Item Name: GWT Knob

Start Date: 1/6/2010

Required Date: 1/13/2010

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010B0.375X03.500		Purchased	No			100	f	13.9600	0.2924	1.5		
1010-1025 Steel Bar .375 x 3.500												



10-1-11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

13.96

102179

2.46

110740

11.5

111369

N/A
N/A
111369

7

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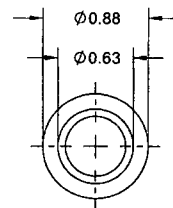
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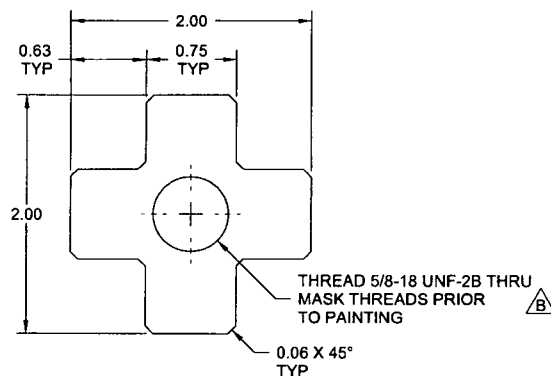
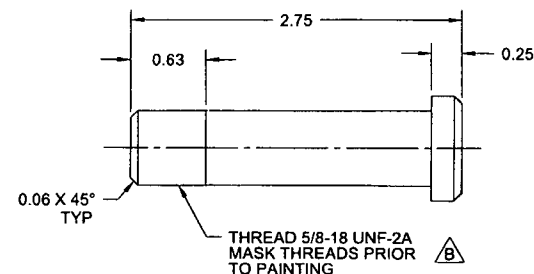
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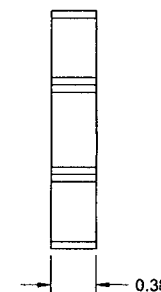
NOTE: Date & initial all entries



D3954-1 GWT PIN



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

ALTERNATE MATERIAL:



-1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CO-10318 PER DART QSI-005-12
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2009-10-19

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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